

Work Order ID 55621

January 25, 2010 12:53:17 PM



Page 1

Item ID: D3492-049

Accept



Setup Start



Revision ID:

Item Name: Plug Assembly

Stop



Start Date: 1/26/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 2/5/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: UMF

Date: 10-1-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

D3492

Rev C

100



Hardinge CNC LATHE SMALL

Hardinge

Memo

Hardinge CNC Lathe Small

I-Turn as per Folio FA713 & Dwg D3492. Dwg Rev: C Folio
Rev: C

30/10/2010

30 ✓

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

30/10/2010

30 ✓

120



QC8- Inspect parts - second check

QC

Memo

Quality Control

30/10/2010

30 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

Small Fab

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Small Fab

Small Fab

Memo

1-Deburr

0.00

30 ✓

SA 10/02/30

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2010-02-01

QC5-
X30

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

10-02-01

10-02-01
B0 ✓

Hand Finishing

| W/O: | | WORK ORDER CHANGES | | | | | |
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Required Date: 2/5/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

10/13/10

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

BK 10-3-10

30 ✓

180



Packaging

Packaging

Identify as per dwg & Stock Location FP-A

0.00

10/3/10

(X30) ✓

Memo

0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 55621

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January 25, 2010 12:53:17 PM

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Cust Item ID:

Required Date: 2/5/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

QC21- Final Inspection - Work Order Release

0.00

10/03/11 JJ

Quality Control

Memo

0.00

MF 10-3-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

January 25, 2010 12:53:17 PM

Page 1

Work Order ID: 55621



Parent Item: D3492-049



Parent Item Name: Plug Assembly

Start Date: 1/26/2010

Required Date: 2/5/2010

Comments: IPP Rev:A New Issue 06-06-20 JLM

Start Qty: 30.00

Required Qty: 30.00

IPP Rev:B as per Rev C 07-12-06 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch Purchased | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|----------------------------------|------------------------|----------------------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6R1.000 ROUND BAR 1.00" | | | | No | | 100 | f | 54.8524 | 1.4463 | | | |

ROUND BAR 1.00"

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 54.8524

108876 8.355

110966 11.6274

113457 34.87

1.7 \$10/01/30

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 55621 |
| Description: Plug | Part Number: | D3492-9 |
| Inspection Dwg: D3492 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | |
|------------------------|-----------------------|-------------------------|
| Measured by: <u>SD</u> | Audited by: <u>DK</u> | Prototype Approval: N/A |
| Date: 10/01/10 | Date: 10/01/10 | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|---------------|---|
| A | 08.02.28 | New Issue | P/O D3492-049 | KJ/DD   |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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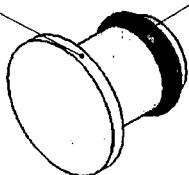
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3492-XX PLUG
(SEE TABLE) NAS1611 PLUG
(SEE TABLE)

#S601

D3492-XXX PLUG PARTS LIST

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -053 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|
| X | X | | | | | | D3492-041 | PLUG ASSEMBLY |
| | | X | | | | | D3492-043 | PLUG ASSEMBLY |
| | | | X | | | | D3492-045 | PLUG ASSEMBLY |
| | | | | X | | | D3492-047 | PLUG ASSEMBLY |
| | | | | | X | | D3492-049 | PLUG ASSEMBLY |
| | | | | | | X | D3492-051 | PLUG ASSEMBLY |
| | | | | | | | D3492-053 | PLUG ASSEMBLY |
| 1 | | | | | | | D3492-1 | PLUG |
| | 1 | | | | | | D3492-3 | PLUG |
| | | 1 | | | | | D3492-5 | PLUG |
| | | | 1 | | | | D3492-7 | PLUG |
| | | | | 1 | | | D3492-9 | PLUG |
| | | | | | 1 | | D3492-11 | PLUG |
| | | | | | | 1 | D3492-13 | PLUG |
| | | | | | | | NAS1611-005 | O-RING |
| | | | | | | | NAS1611-007 | O-RING |
| 4 | | | | | | | NAS1611-010 | O-RING |
| | | | | | | | NAS1611-012 | O-RING |
| | | | | | | | NAS1611-013 | O-RING |
| | | | | | | | NAS1611-015 | O-RING |
| | | | | | | | NAS1611-016 | O-RING |

△ △ △

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~
C.04.1.001
OK NSS 08.11.12

DEO ATTACHED

RELEASED
S:11.16/11/12

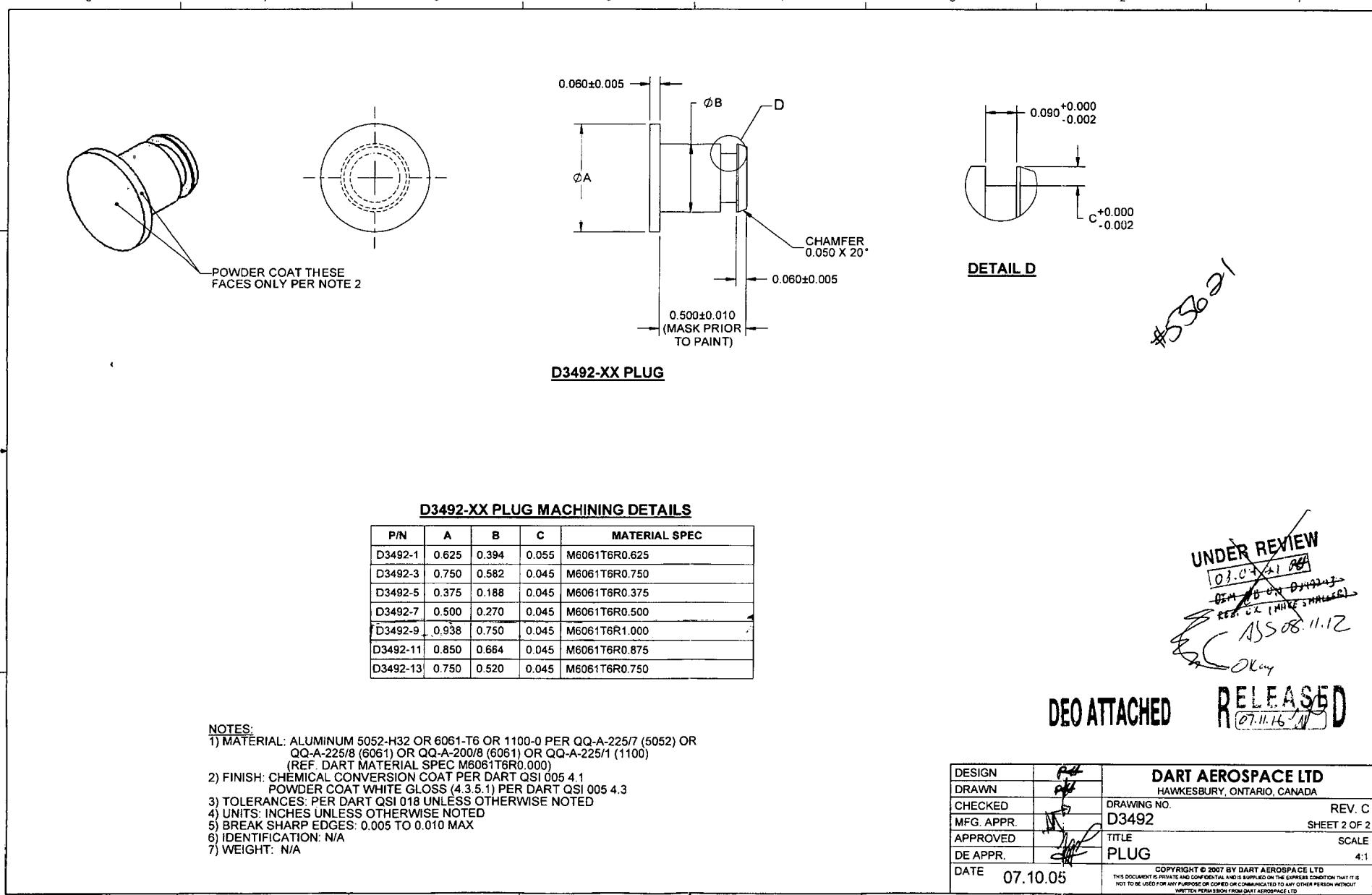
| | | | |
|------------|---|---|--------------|
| C | ADD -049-051-053, CHANGE DRAWING FORMAT | PH | 07.10.05 |
| B | ADD -047; UPDATE DIM A FOR -045 | PH | 06.05.11 |
| A | NEW ISSUE | PH | 06.01.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>✓</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | <i>✓</i> | DRAWING NO. | REV. C |
| CHECKED | <i>✓</i> | D3492 | SHEET 1 OF 2 |
| MFG. APPR. | <i>✓</i> | APPROVED | SCALE |
| DE APPR. | <i>✓</i> | PLUG | 2:1 |
| DATE | 07.10.05 | COPRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



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NOTE: Date & initial all entries

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|------------------------|---------------|---------------------|---|---------------|---------------|-------------------------|---------------------------|--------------|
| DRAWING NO. D3492 | TITLE PLUG | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | | D.E.O. NO. D3492-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN DATE 08.11.05 | AJS | CHECKED 08.11.05 | MFG. APPR. E | APPROVED M | DE APPR. | | | |
| | | | DATE 08.11.05 | DATE 08.11.05 | DATE 08.11.05 | DATE 08.11.05 | DATE 08.11.05 | |

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.510 | 0.045 | M6061T6R0.750 |

#5562

WAS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

RELEASED
08/11/10 MM

| W/O: | | WORK ORDER CHANGES | | | | | |
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